

Work Order ID 51137

August 4, 2009 1:51:46 PM



Page 1

Item ID: D3929-042
Revision ID: A
Item Name: Gusset Assembly

Accept



Setup Start



Stop



Start Date: 8/06/09 Start Qty: 6.00
Required Date: 8/14/09 Req'd Qty: 6.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

100		0.00
-----	--	------



Waterjet
FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3929
Dwg Rev: A
Prog Rev: A

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	---	------



QC
Quality Control

Memo

0.00

1B 9-8-5

1B 9-8-5

9

9

(PTO)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-08-10	W/O header	Add Dwg D3929 : Rev.A to the box Perm. Change	FL	09-08-10		09-08-10	09-08-10

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51137

August 4, 2009 1:51:46 PM



Page 2

Item ID: D3929-042
Revision ID: A
Item Name: Gusset Assembly

Accept



Setup Start



Stop



Start Date: 8/06/09 Start Qty: 6.00
Required Date: 8/14/09 Req'd Qty: 6.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	27	809/08/05		(XS)	φ		
130 Packaging Packaging	Pick Kit Memo	0.00 0.00							
140 Large Fab Large Fab	Weld bushings D3907-1 as per dwg D3929 316L rod batch: <u>M109213</u>	0.00 0.00							

SY 09/08/11 (9x)

SY 09/08/06 9x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51137



Page 3

August 4, 2009 1:51:46 PM

Item ID: D3929-042
Revision ID: A
Item Name: Gusset Assembly

Accept



Setup Start



Stop



Start Date: 8/06/09 Start Qty: 6.00
Required Date: 8/14/09 Req'd Qty: 6.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
						PD 09.08.06			
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
						⇒ 808108166			
						(XS) 4			
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>Basket</u> Memo	0.00 0.00							
						PD 09.08.06			
						(9)			

Work Order ID 51137



Page 4

August 4, 2009 1:51:46 PM

Item ID: D3929-042
Revision ID: A
Item Name: Gusset Assembly

Accept



Setup Start



Stop



Start Date: 8/06/09 Start Qty: 6.00
Required Date: 8/14/09 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							 09-08-10 mf 09-08-06

Picklist Print

August 4, 2009 1:51:45 PM

Work Order ID: 51137

Parent Item: D3929-042RevA

Parent Item Name: Gusset Assembly


Comments:

Start Date: 8/06/09

Required Date: 8/14/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	89.5109	2.8421	9		
304/316 0.125 Sheet												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

89.51090316

111018

89.5109032

D3907-1RevA

Manufactured

No

130

Each

46.0000

12.0000



Bushing

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

46

50944

46

111018

18 9-8-5

Ⓟ

18

SY 09/08/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

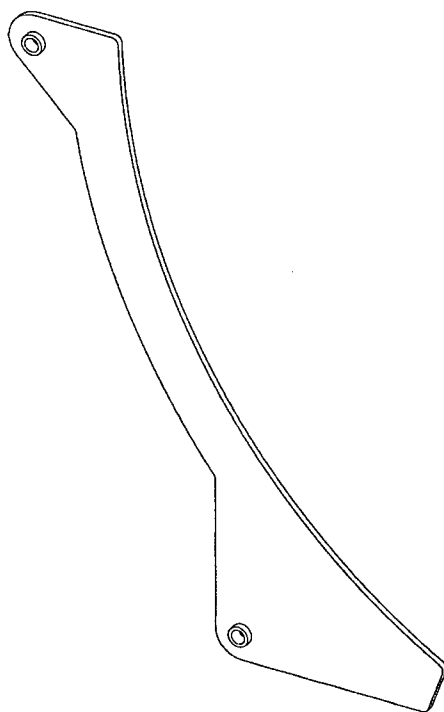
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

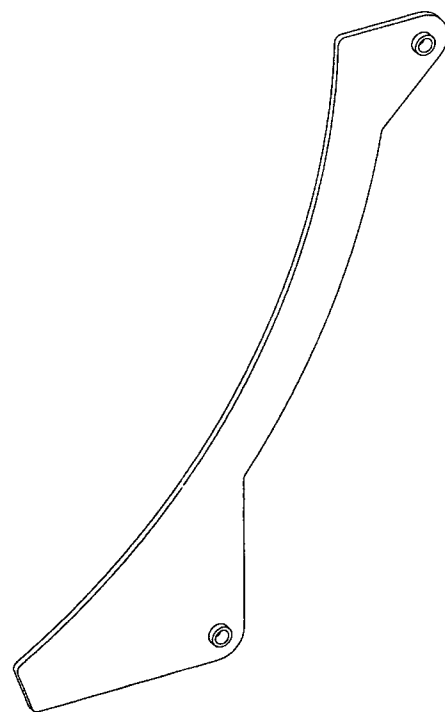
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

W/O
5037

RELEASED
8/6/12

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE		MB	09.04.03
REV.		DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.04.03			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3929	REV. A
TITLE GUSSET ASSEMBLY	SHEET 1 OF 3
SCALE NTS	
COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

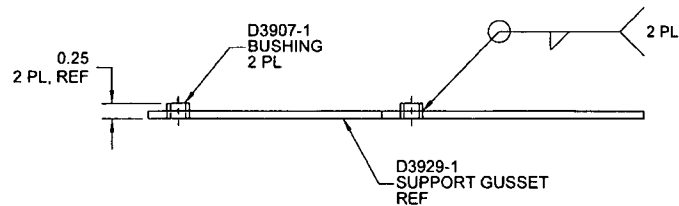
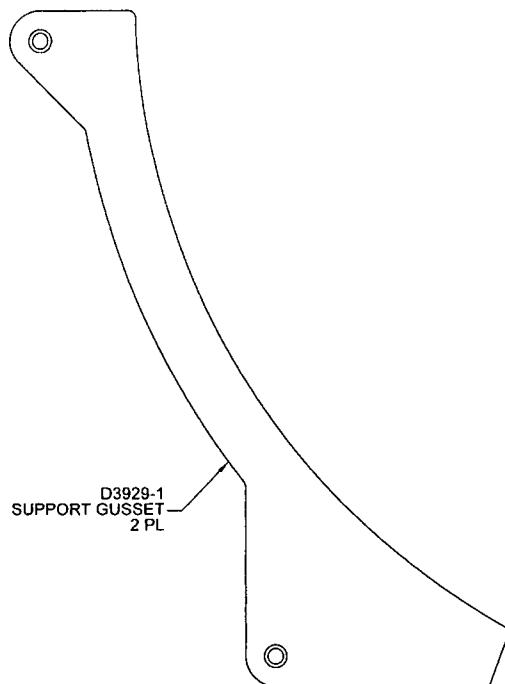
8 7 6 5 4 3 2 1

D

C

B

A



D3929-041 GUSSET ASSEMBLY

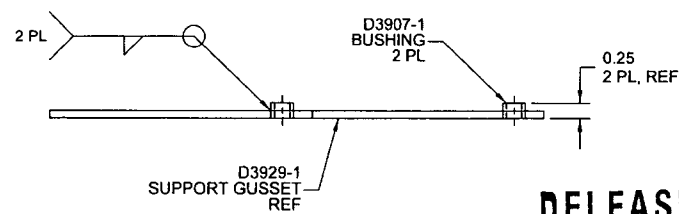
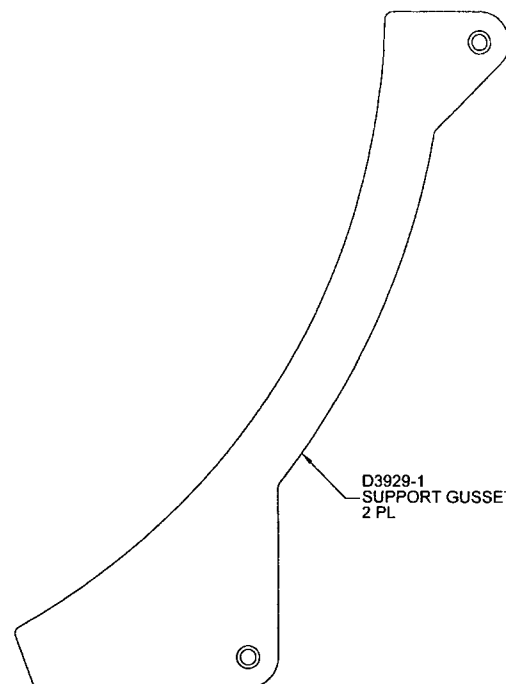
W/O 51137

D

C

B

A



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/03

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
DATE	09.04.03	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

